

Work Order ID 131051

131051

Page 1

March-26-15 1:38:36 PM

Item ID: D4365-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar
 Start Date: 3/25/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 3/26/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: ULS Date: 15-03-27 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4365	A								
100		0.00				4	0		J.C., L. 15/04/02
100									
Cold Saw	Memo	0.00							
Hyd Mech	Cut blanks at 43.35"								
110		0.00				4	0		J.C., L. 15/04/02
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Mill as per folio FB040 & dwg D4365, FOLIO REV: _____ DWG REV: <u>A</u>								
	2-Deburr as required								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Doc/Data									
Equip/Tooling									
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Training									
Transport									
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131051

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 3/25/15 **Start Qty:** 4.00

4

Required Date: 3/26/15 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

MLJ 15-04-07

15-4-7

DQA: _____ Date: _____



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Picklist Print

March-26-15 1:38:35 PM

Page 1

Work Order ID: 131051

131051

Parent Item: D4365-1

D4365-1

Parent Item Name: Bar

Start Date: 3/25/15

Required Date: 3/26/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.04.12 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304B0.250x0.500

Purchased

No

100

f

358.4560

3.625

16

M304B0 250x0 500

304 BAR .250 x .500

J.C.L. 15/04/02

Location

Loc Qty

Loc Code

MAT009

358.456

m129366

32.316

m131205

36.1

m131748

290.04

~~3.62~~ 14.47'
3.62'
10.85'
~~8~~

DQA: _____ Date: _____



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D4365-1 BAR

D4365-3 BAR

UNCLASSIFIED
EXCLUDED FROM AUTOMATIC
DOWNGRADING AND
DECLASSIFICATION

131051

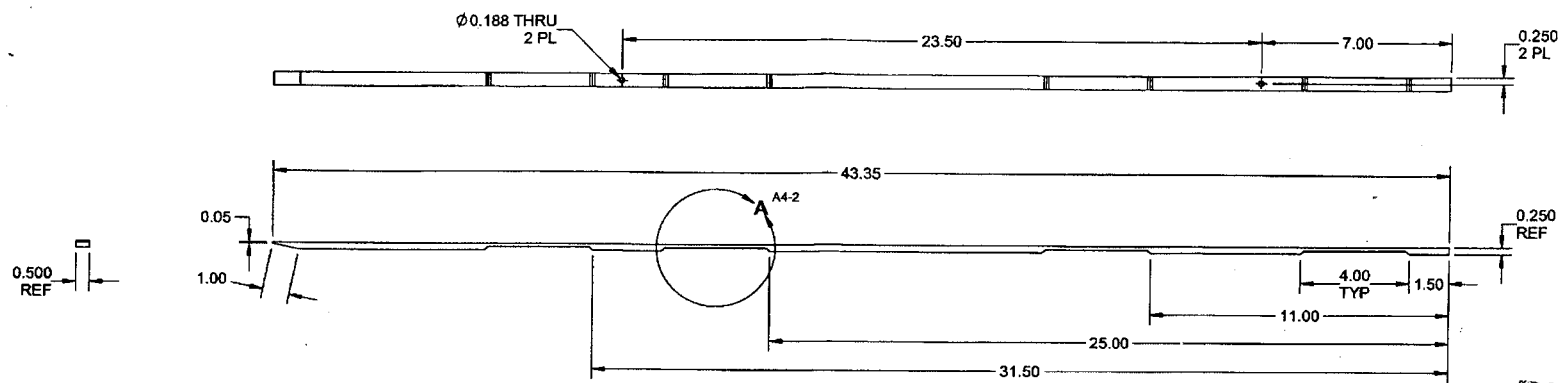
ML5

1503-27

RELEASED
2011-09-12

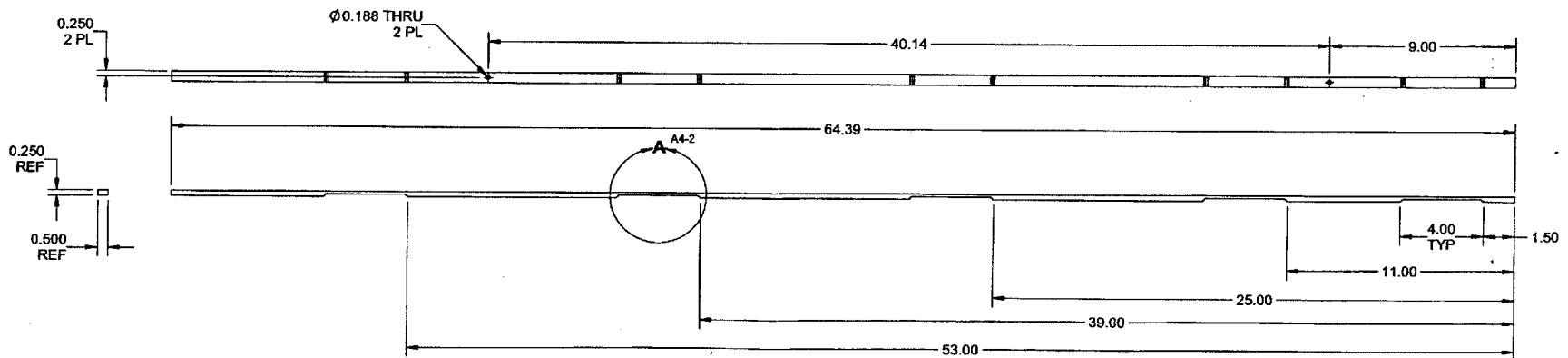
A	NEW ISSUE	SC	11.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC	DRAWING NO.	REV. A
CHECKED	SC	D4365	SHEET 1 OF 2
MFG. APPR.	SC	TITLE	SCALE
APPROVED	SC	BAR	NTS
DE APPR.	SC	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DATE	11.06.14		

8 7 6 5 4 3 2 1



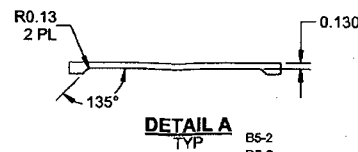
D4365-1 BAR

RELEASED
2011-09-12
MD



D4365-3 BAR

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR. 0.250 THICK X 0.500 WIDE
PER ASTM A276 OR ASTM A240
REF. DART SPEC. M304B0.250X00.500
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: D4365-1 = 1.28 lbs
D4365-3 = 1.98 lbs



DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	AP	DRAWING NO. D4365	REV. A
MFG. APPR.	B		SHEET 2 OF 2
APPROVED	MD	TITLE BAR	SCALE NTS
DE APPR.			
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8 7 6 5 4 3 2 1